

Shp ASAP 11/01-12/01

Work Order ID 65103

January 6, 2011 10:38:49 AM



Item ID: D3023-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Panel

Start Date: 1/06/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/11/11 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3023

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3023

Dwg Rev: *[Signature]*

Prog Rev: *[Signature]*

***graind direction along 28.100" ***

2-Deburr if necessary

B11-6

①

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65103

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Required Date: 1/11/11 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

Silaboz

130



Brake NC

Brake NC

NC BRAKE

Memo

1-Bend as per Dwg D3023 2-form edge of back pan as per dwg D3023 using D3017-041 back frame

0.00

0.00

SP 11/01/10

EL. 11-1-10

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Silaboz

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 65103

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Start Date: 1/06/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/11/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

=> M 11/01/10

1 0

Memo

0.00

160



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M112588

=> M 1/11/08

1 0

Memo

0.00

START TIME:

1:30pm

OVEN TEMPERATURE:

326°C FINISH TIME:

2:00pm

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

11/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65103

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Setup Start



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Item Name: Back Panel

Start Date: 1/06/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/11/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

PPP 65103

0.00

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11-07-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

January 6, 2011 10:38:48 AM

Page 1

Work Order ID: 65103

Parent Item: D3023-1

Parent Item Name: Back Panel



Start Date: 1/06/11

Required Date: 1/11/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C 02.01.23 Revised NG
IPP Rev:D 08-04-16 now water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.032

Purchased

No

100

sf

68.7832

2.8777

3.029158



2024-T3 .032 sheet



1-1-6

1

Location

Loc Qty

Loc Code

MAT22

68.783158

105555

3

111699

4

113189

61.783158

113189

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 65103
Description: Back Panel		Part Number: D3023-1
Inspection Dwg: D3023	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

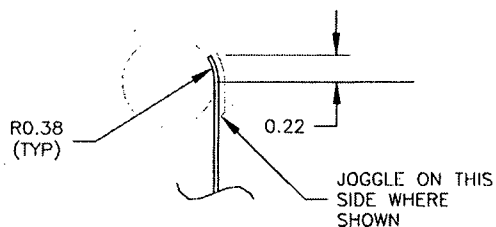
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.132	X		V 1802	
Ø0.191	+0.005/-0.001	.193	X		V	
1.660	+/-0.010	1.660	X		V	
0.375	+/-0.010	.376	X		V	
1.340	+/-0.010	1.343	X			
2.375	+/-0.010	2.374	X			
0.375	+/-0.010	.376	X			
25.28	+/-0.030	25.28	X		T-m	
27.03	+/-0.030	27.03	X		+m	
28.10	+/-0.030	28.10	X			
1.30	+/-0.030	1.302	X			
2.375	+/-0.010	2.375	X			
8.711	+/-0.010	8.711	X			
5.597	+/-0.010	5.597	X			
8.57	+/-0.030	8.57	X			
1.970	+/-0.010	1.972	X			
7.42	+/-0.030	7.42	X			
10.92	+/-0.030	10.92	X			
14.75	+/-0.030	14.75	X		T-m	

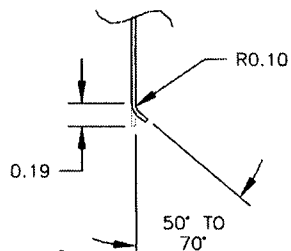
Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-1-6	Date: 11/01/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC	

SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)

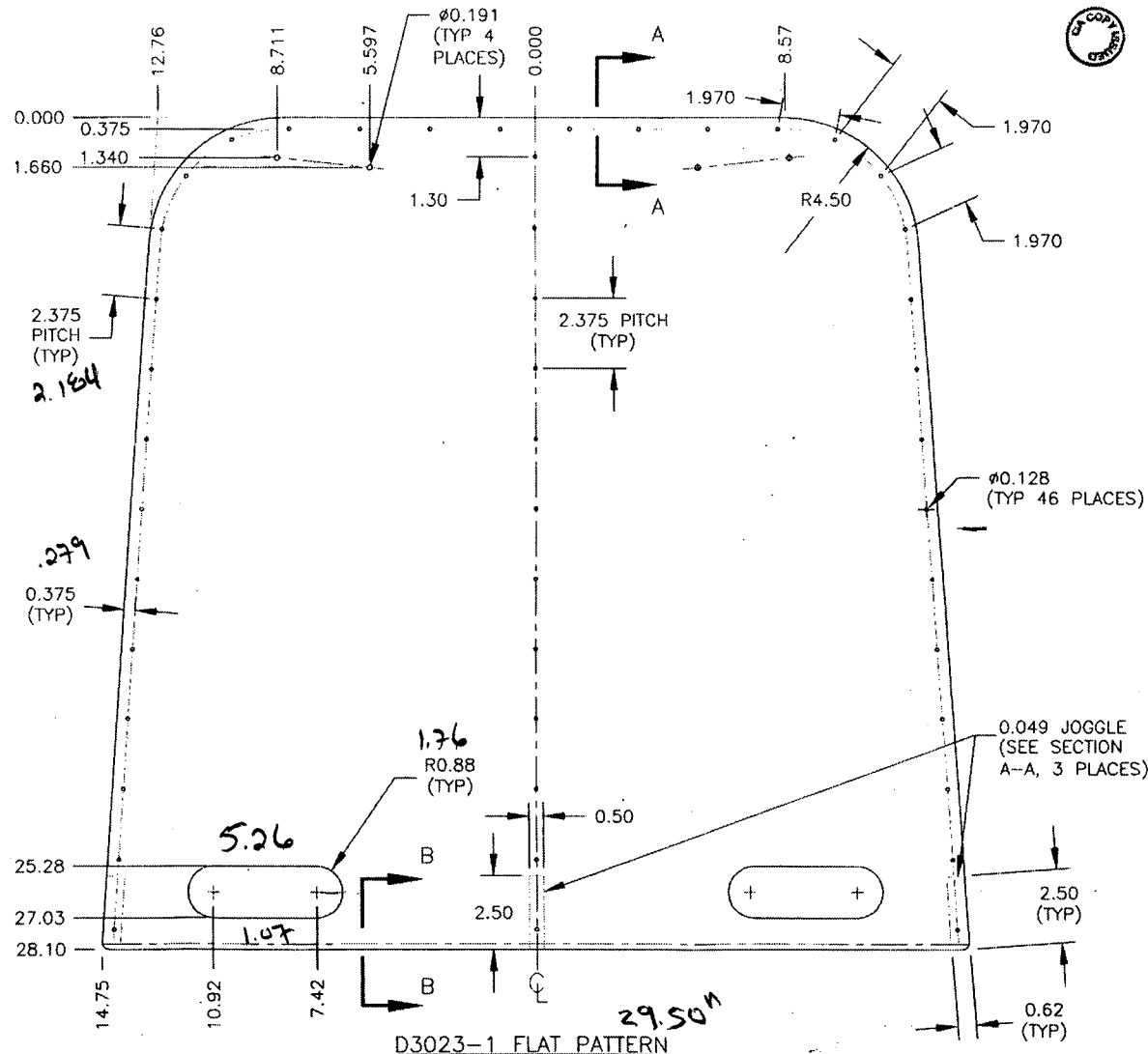


SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)



RELEASED
9.06.07

D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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A	01.05.18	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, CANADA
CHECKED	APPROVED	DRAWING NO. D3023
DATE	01.05.18	TITLE BACK PANEL
		REV. A SHEET 1 OF 1 SCALE 1:4

who 65103